

Work Order ID 112716***112716***

Page 1

Item ID: D4027-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hose Clamp Assembly

Start Date: 2/5/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 2/6/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: JMF Date: 14-2-5 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4027	A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Drill hole and assemble as per dwg notes

3m contact cement: m 127443

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: ST449

0.00

120

Packaging

Memo

0.00

Packaging

8

8

8x DAS 28 14-02-7
9-89

Work Order ID 112716

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112716

Page 2

Item ID: D4027-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Hose Clamp Assembly

Stop *NS2*

Start Date: 2/5/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 2/6/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

PL 14-02-10
(H) 14-02-10

Picklist Print

Wednesday, February 05, 2014 2:58:47 P

Page 1

Work Order ID: 112716

Parent Item: D4027-041

Parent Item Name: Hose Clamp Assembly


Start Date: 2/5/2014

Required Date: 2/6/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by:JLM IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4027-1 Hose Clamp		Manufactured	No			100	Each	16.0000	1	8	FF	07-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST449		16							
				105827		16							
 D4027-57 Rubber Cushion	14.02.06	Manufactured	No			100	Each	2.0000	1	8	FF	07-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2							
				83970		2							
				89457									
AN743-13 Bracket		Purchased	No			100	Each	40.0000	1	8	FF	07-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		40							
				M126010		8							
				M126119		12							
				M126249		20							
MS24693-S28 Screw		Purchased	No			100	Each	97.0000	1	8	FF	07-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST301		97							
				11334		46							
				4824		10							
				8170		41							
NAS1149DN632J Washer		Purchased	No			100	Each	286.0000	1	8	FF	07-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST293		286							
				M126084		186							
				M127255		100							

Picklist Print

Wednesday, February 05, 2014 2:58:47 P

Page 2

Work Order ID: 112716

Parent Item: D4027-041


Start Date: 2/5/2014

Required Date: 2/6/2014

Parent Item Name: Hose Clamp Assembly

Start Qty: 8.00

Required Qty: 8.00

 MS21042L09^α

Purchased

No

127304

100

Each

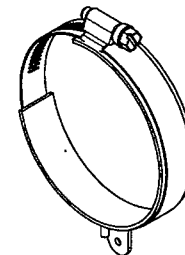
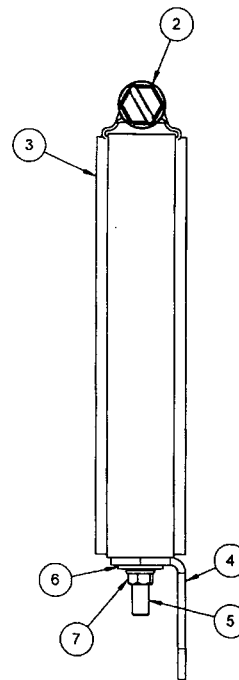
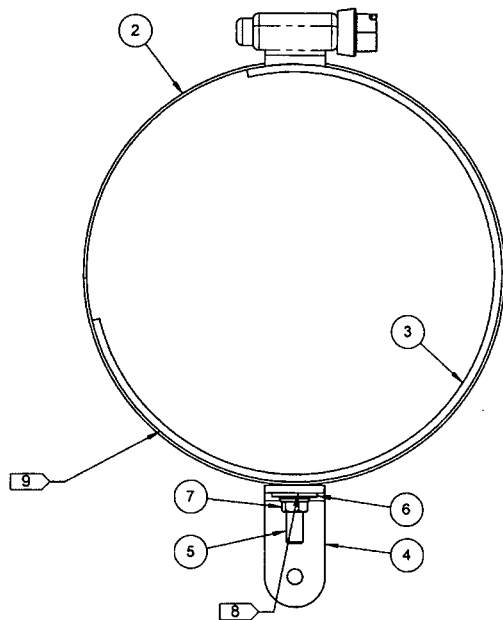
0.0000

1

8 FF 07-02-14

Nut

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5 <i>7</i>	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



MF
110716
14-2-5

RELEASED
2010-05-05
mf

D4027-041 VENT CLAMP ASSEMBLY

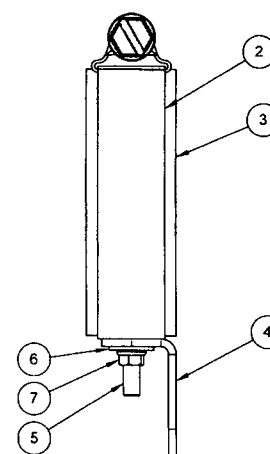
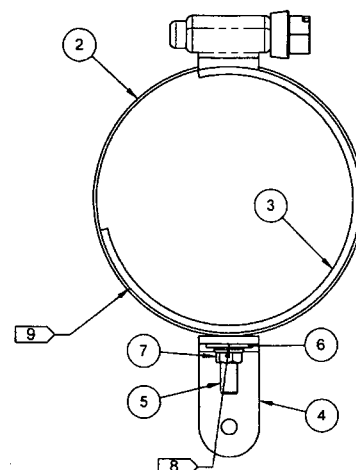
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

A	NEW ISSUE	BY	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4027	REV. A
TITLE CLAMP	SCALE NTS
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35
2	1	D4027-3	HOSE CLAMP	
3	1	D4027-7	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT CLAMP	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



#112716

D4027-043 VENT CLAMP ASSEMBLY

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2010-05-05
N/A

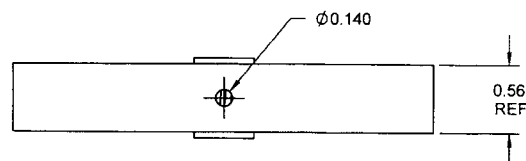
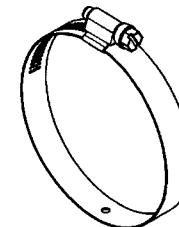
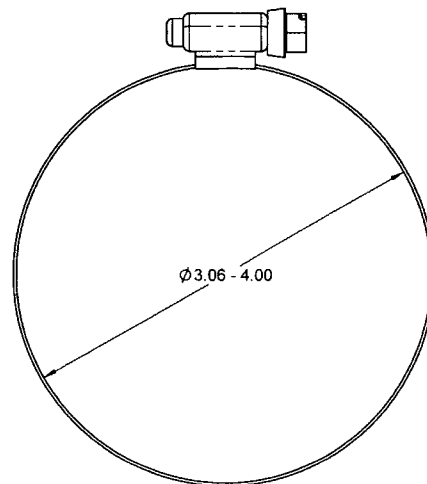
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

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DE APPR.		REV. A
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20



D4027-1 HOSE CLAMP

#112716

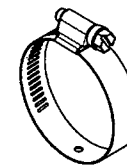
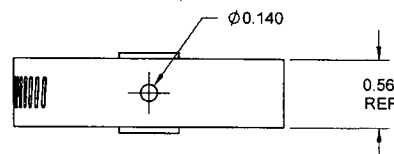
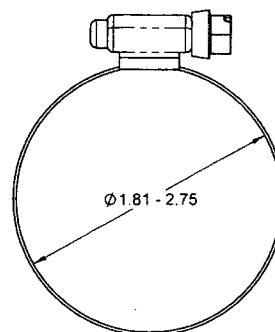
RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: MADE FROM QS200M56S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø 0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-3	REF JCA-M47-2-35



#112716

D4027-3 HOSE CLAMP

RELEASED
2010-05-05
MJD

NOTES:

- 1) MATERIAL: MADE FROM QS200M36S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-5	REF JCA-M47-2-20
D4027-7	REF JCA-M47-2-35

D

C

B

A

0.06
REF

0.75

L

DART PART NUMBER	LENGTH "L"
D4027-5	5.30
D4027-7	8.25

D4027-X RUBBER CUSHION

#112716

RELEASED
 2010-05-05
 MW

NOTES:

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF DART SPEC M-NEO-60-S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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7

6

5

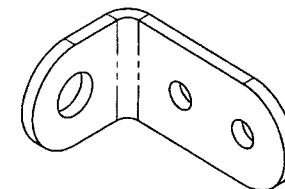
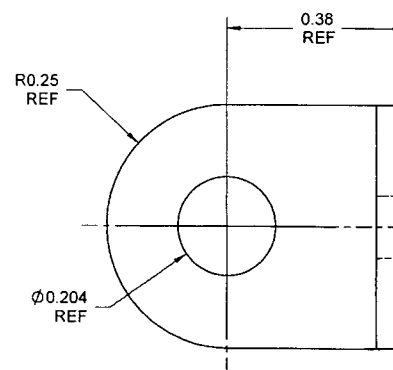
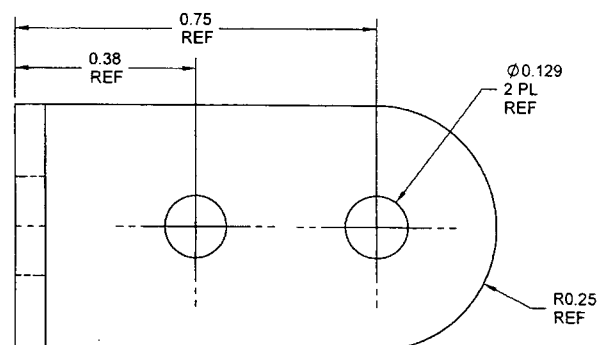
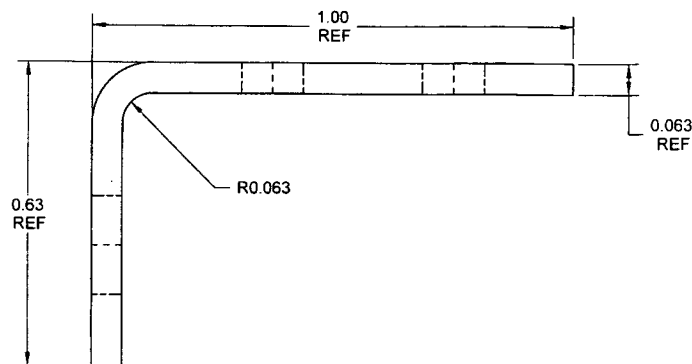
4

3

2

1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-9	REF JCA-M47-2-20/-35



D4027-9 BRACKET, SUPPORT ANGLE

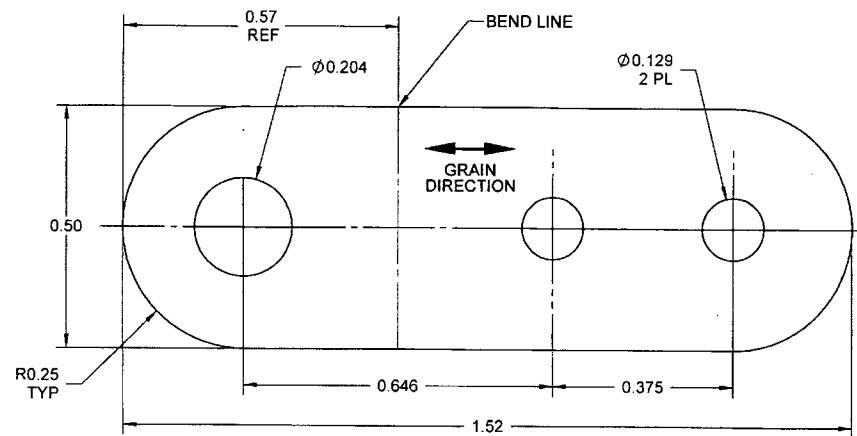
NOTES:

- 1) MATERIAL: MADE FROM D4027-9F OR EQUIVALENT TO AN743-C13
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

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RELEASED
2010-05-05
WPD

112714



#112714

D4027-9F FLAT PATTERN

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 THICK
PER AMS5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

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